

Work Order ID 132419

132419

Page 1

May-07-15 2:41:25 PM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: **3** Stop ***NS2***
 Item Name: Collective Lock AS350
 Start Date: 5/07/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								

100 0.00
100 Small Fab 3 FF JUN 15 2015
 Small Fab Memo 0.00
 Small Fab Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
 Identify as D3372-3

110 0.00
110 QC5- Inspect part completeness to step on W/O DAS
 QC 30 3 JUN 15 2015
 Quality Control Memo 0.00

120 0.00
120 Small Fab 3 FF JUN 15 2015
 Small Fab Memo 0.00
 Small Fab 1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
 lock barrel. Discard the rest.
~~2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as~~
~~D3369-5~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

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130	Small Fab	0.00							
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130

Small Fab	Memo	0.00				3	FF	JUN 15 2015	
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Small Fab

Memo

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	M132202

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

140	Large Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

140

Large Fab

Memo

Tack weld lock shaft as per Dwg D3372

A/R	SS Rod	Batch
		122077

Large Fab

3

15-06-15
JR

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u 13.06.17

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID: 132419

132419

Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID 06.03.21 EC
added D3384-043 DD 10.05.13 verified :EC IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC *5/16WC* Washer		Purchased	No			100	Each	144.0000	2	2			
									**			FF JUN 15 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st572			144					
					m131961			144					
AN5-42A *AN5-42A* Bolt		Purchased	No			100	Each	15.0000	1	1			
									**			FF JUN 15 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST336			15					
					m127475			15					
D3372-1 *D3372-1* Main Body		Manufactured	No			100	Each	0.0000	1	1			
									**			FF JUN 15 2015	
D3372-5 *D3372-5* Cam Lock Shaft		Manufactured	No			100	Each	24.0000	1	1			
									**			FF JUN 15 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST035			24					
					122931			12					
					123362			12					

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Parent Item Name: Collective Lock AS350

132419

D3372-041

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

D3372-7 Manufactured No

100 Each 5.0000 1 1

D3372-7

Slider Body

**

FF JUN 15 2015

Location

Loc Qty

Loc Code

ST498A

4

123431

4

ST499

1

123005

1

D3373-1 Manufactured No

100 Each 14.0000 1 1

D3373-1

Cam Lock

**

FF JUN 15 2015

Location

Loc Qty

Loc Code

GA

1

105986

1

ST035

13

121920

8

74862

5

D3384-043 Manufactured No

100 Each 3.0000 1 1

D3384-043

Cyclic Sock Assembly

**

FF JUN 15 2015

Location

Loc Qty

Loc Code

ST500

3

123385

3

HX-81 Purchased No

100 Each 71.0000 1 1

HX-81

1/4"-20 SHCS 3/8" long

**

FF JUN 15 2015

Location

Loc Qty

Loc Code

ST554

71

123436

71

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Shop Packet Print

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Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0463P

Purchased

No

100

Each

1,303.000

2

2

NAS1149F0463P

Washer

FF

JUN 15 2015

Location

Loc Qty

Loc Code

ST260a

984

m127832

984

st268

319

m127832

295

m130388

24

26

3

FF

JUN 15 2015

3369-5 (41) Batch 1 B102813

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong															
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions															
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance															
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect															
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing															
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved															
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing															
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish															
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread															
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence															
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :																					
Misidentified ☐	☐	Past Due	☐																						